

Date: Friday, 06/06/2008 8:32:05 AM
User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	WEARPLATE
Job Number :	36170		
Estimate Number :	10743		
P.O. Number :		Part Number :	D33152
This Issue :	06/06/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3315 REV. B
First Issue :	07/12/2007	Project Number :	N/A
Previous Run :	36170	Drawing Revision :	B
	Type :	Material :	
	SMALL /MED FAB	Due Date :	24/12/2007
Written By :			Qty: 6 Um: Each
Checked & Approved By :			
Comment :	Est: A 05.05.12 New issue KJ/JLM Est Rev:B As per Rev B 06-03-24 JLM Est RevC now water jet 07-12-06 DD		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M1010S16GA	1010/1025/A21/6aA SHEET



Comment: Qty.: 1.6950 sf(s)/Unit Total : 10.1700 sf(s)
1010/1025/A21/6aA SHEET
batch 105706 HB 07-12-11

2.0	WATER JET	FLOW WATER JET
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Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs
FLOW WATER JET
1-Cut as per Dwg D
Dwg Rev: B HB 07-12-11
Prog Rev: B

2-Deburr if necessary HB 07-12-11

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs
INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs
SECOND CHECK

807/12-11 x6

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Part Number: D33152

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
SMALL & MEDIUM FAB RESOURCE 1
Deburr if necessary

Done at Step 2.2

6.0

BRAKE NC

NC BRAKE



Comment: Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
NC BRAKE

1- Form using DT8751 Die as per Dwg D3315 Rev: *D*

2- Form using DT8179 Die and form joggle using DT8157 as per Dwg D3315 Rev: *B*

SP 08/01/09

7.0

QC6

DIMENSIONAL CHECK



Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs
DIMENSIONAL CHECK,

08/01/09 (46)

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
LARGE FABRICATION RESOURCE 1

Weld hard surface using D3315-2T3 as per QSI 004 and Dwg D3315 Rev: *B*

Qty Part Number Description Batch

A/R N/A 7560 Hardcoat Rod

m107533

08 06 10 6

9.0

~~QC6~~ *QC 10*

VISUAL WELDING INSPECTION



Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs
VISUAL WELDING INSPECTION

08/06/09 (46)

30/8/25
S.005
#1
#2
#3
#4

10.0

POWDER COATING

POWDER COATING



Comment: Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M10S 642

M-1 08/06/10

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs
INSPECT POWDER COAT

FL 08/06/10 (6)

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 36170

Part Number: D33152

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

PACKAGING 1

PACKAGING RESOURCE #1



6x

Comment: Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

PACKAGING RESOURCE #1

Identify on inside surface using a permanent fine point marker with the following:

TCCA-PDA, Dart Aerospace Ltd.

P/N: D3315-2, B/N: BXXXXX

For Product Eligibility see PDA04-17

and Stock

Location: 495

8/4/11

SD

13.0

QC21

FINAL INSPECTION/W/O RELEASE



08/06/12

Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-06-12

Date: Friday, 06/06/2008 8:31:45 AM

User: Linda Lacelle

JOB HISTORY : DETAIL

Job Number	: 36170	Customer	: Dart Helicopters Services
Estimate Number	: 10743	DWG Name	: WEARPLATE
Purchase Order #	:	Part Number	: D33152
Complete Date	: / / : : AM	DWG Number	: D3315 REV. B
		Rev.	: B

DUE DATE	ORDERED	DELIVERED
24/12/2007	6	0

1.0 M1010S16GA-1010/1025/A21/6aA SHEET INVENTORY ITEM					
DATE	EMPLOYEE	TYPE	Qty	COST	
11/12/2007	BLEC01: Bleck, Henry	M1010S16GA	10.170	\$36.18	Lot # 105706 Qty. 10
Subtotal: QTD: 0 CTD: 10 \$36.18					

2.0 WATER JET Internal Operation							
DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach. Cost
11/12/2007	BLEC01: Bleck, Henry	Run	6.000	0.92	\$14.31	0.92	18.89
Subtotal: QTD: 6 CTD: 0 0.92 \$33.20							

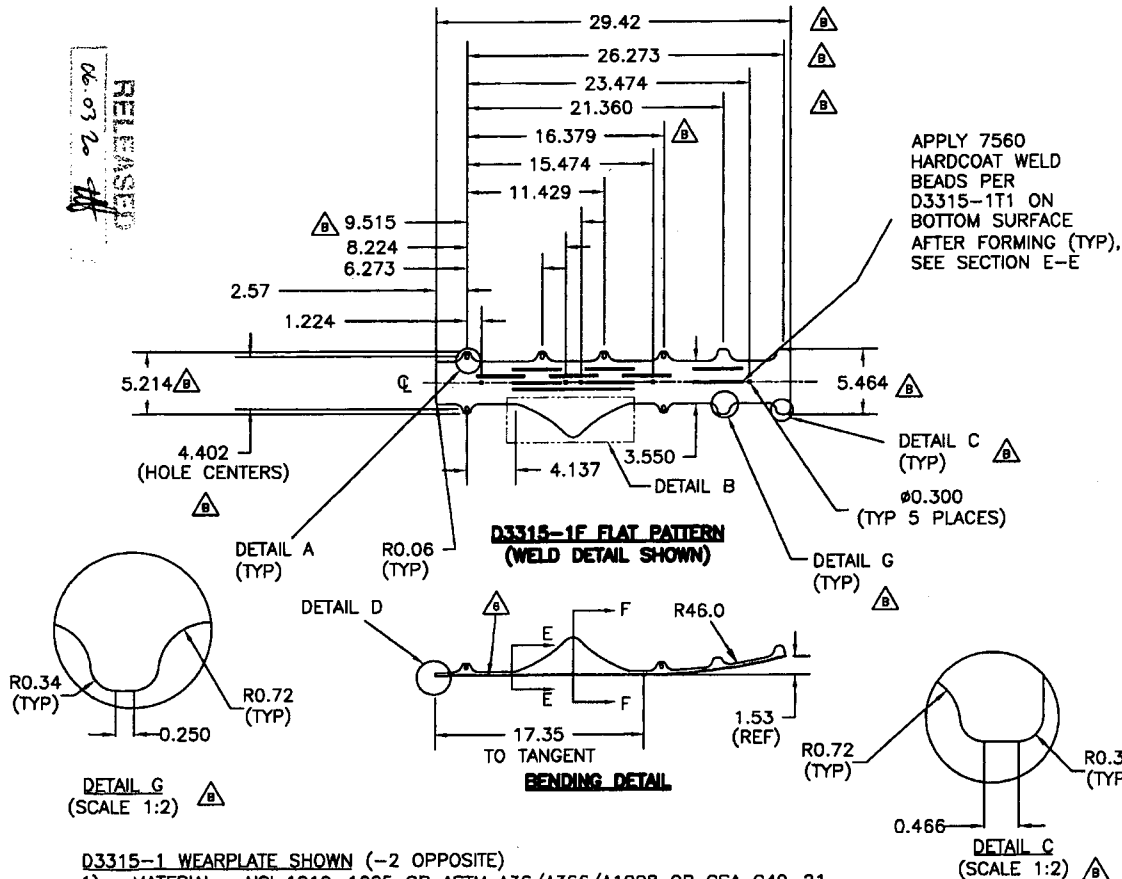
6.0 BRAKE NC Internal Operation							
DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach. Cost
09/01/2008	BOUC01: Boucher, Sylvie	Run	0.000	0.32	\$4.98	0.32	6.57
11/01/2008	BOUC01: Boucher, Sylvie	Run	6.000	0.39	\$6.06	0.39	8.00
Subtotal: QTD: 6 CTD: 0 0.71 \$25.61							

		TIME	COST
Machine Time:		1.63	\$33.46
Labor:		1.63	\$25.35
Sub-contract (external Op.):			\$0.00
INVENTORY ITEM:			\$36.18
SUB-COMPONENT (SUB-JOB):			\$0.00
Total:			\$94.99

COST PER UNIT: \$94.99

DART

DESIGN	04	DRAWN BY	04	DART AEROSPACE LTD
CHECKED		APPROVED		HAMKESBURY, ONTARIO, CANADA
DATE	06.01.31	TITLE	D3315	REV B
		WEARPLATE		SHEET 1 OF 4
		SCALE	1:12	
		UPDATE DIMENSIONS		



D3315-1 WEARPLATE SHOWN (-2 OPPOSITE)

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED
TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

W/O 36170

RELEASED
06.03.20